

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009205**Date Inspected:** 17-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Zhong An		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 9-

This Caltrans QA Inspector performed Magnetic Particle Testing verification of OBG Deck Panel Tack welds for DP3068-001-001 through 010 after ZPMC initial MT inspection. ZPMC personnel have made repairs of areas found unacceptable. ZPMC has not performed the final MT of the repair areas. No relevant indications were found during this in process inspection.

Bay 11-

This QA Inspector performed Magnetic Particle Testing (MT) verification of West Tower Lift 3 Corner weld seam WSTL3-4 B/K-84A/B previously tested and accepted by ZPMC QC. This QA inspector generated a MT report for this date. Caltrans QA signed green tag document 10434 along with ABF and ZPMC QC. The Green Tag document excluded exterior areas of the weld not accessible at supporting rings and 1330 mm of weld at the top end of the West Tower Lift 3.

Bay 10:

This QA Inspector observed the following work in progress: FCAW welding of North Tower Lift 3 weld joint

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SPSA3-56-3B. ZPMC welder was identified as 040533. ZPMC QC is identified as Ma Yun. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-TC-U5-F.

FCAW repair welding of North Tower Lift 3 Skin Plate B to C corner joint, NSTL3-3 C/K 82A. ZPMC welder was identified as 040343. ZPMC QC is identified as Liu Zhong An. The welding appeared to be in conformance with welding procedure specification, WPS-345-FCAW-2G(2F)-Repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
